

Date: Monday, 25/05/2009 12:48:51 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACER
Job Number :	48196		
Estimate Number :	11379		
P.O. Number :		Part Number :	D33963
This Issue :	25/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3396 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	45667	Drawing Revision :	B
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	01/06/2009
Written By :		Qty:	50
Checked & Approved By :	<u>JUD 09.05.25</u>	Um:	Each
Comment :	Est A 05.10.03 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINR0750	Delrin Round Bar 0.75"
-----	-------------	------------------------



Comment: Qty.: 0.0368 f(s)/Unit Total : 1.8375 f(s)
 Delrin Round Bar 0.75"
 Material: Ø0.750" Black Delrin Round Bar
 (M-DELIN-R0.750)
 Identify for D3396-3
 Batch: ML10962

JP 09.05.26

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Turn as per Folio FA514 and Dwg D3396
 Deburr

JP 09.05.26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



(52)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP 09.05.26

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JP 09/05/26

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



(524)

Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 93

9/5/26

JP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 48196

Part Number: D33963

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

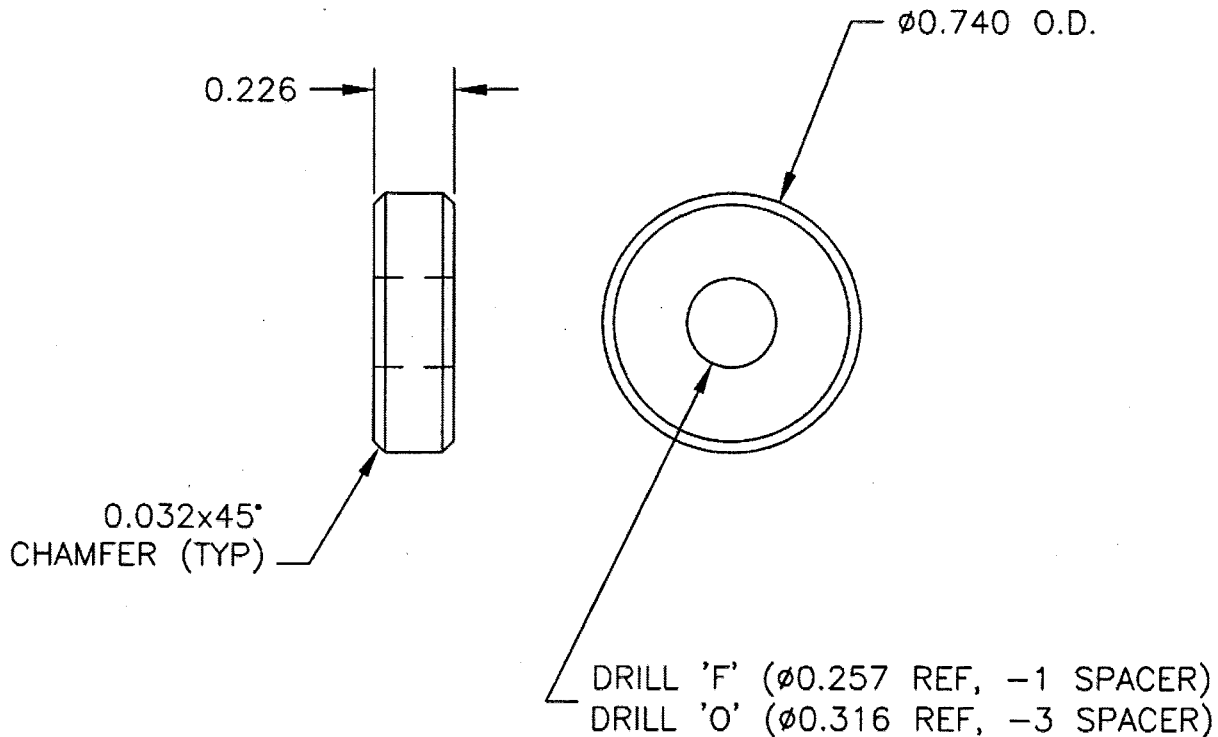
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 1
				D3396	
DATE	05.04.27			TITLE	SCALE
				SPACER	2:1
A	05.03.10			NEW ISSUE	
B	05.04.27			ADD -3	

RELEASED
05-09-06 *[Signature]*

**D3396-1/-3 SPACER**

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4897

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